

Work Order ID 52890

October 19, 2009 8:35:32 AM



Page 1

Item ID: D3798-041
Revision ID: B
Item Name: Spacepod Floor

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/20/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *W*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3798

Rev. B.

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-1
Dwg Rev: *B*
Prog Rev: *B*
2-Deburr if necessary

HB 9-10-19

①

P10
last page

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

template D3798-IT1

HB 9-10-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

template D3798-IT1

2) 8 Oct 2009

④

4

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Page 2

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Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/20/09 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

Small Fab

Memo

0.00

Small Fab

1- C'sink as per dwg D3798-1

2- Deburr if necessary

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

4/30/10/20 ①

2) 507/10/20

⑩ f

1/2 09-10-20

⑩

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Page 3

Item ID: D3798-041

Revision ID: B

Item Name: Spacepod Floor

Start Date: 10/19/09 Start Qty: 1.00

Required Date: 10/20/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Memo

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3798-1 to D3798-5 as per dwg

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



09/10/20

(X1)

φ

09/10/20 (1)

09/10/20

(X1)

φ

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Setup Start



Stop



Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/20/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190
 Powdercoat
Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M109091

0.00

⇒ M 09/10 to

(X1)

Ø

Memo

POWDER COAT:

Start Time: 10:30AM

Oven Temperature: 320°F

Finish Time: 10:00AM

200
 QC
Quality Control

QC3- Inspect Part Finish

0.00

BR 09-10-20

①,

Memo

0.00

210
 Small Fab
Small Fab

Memo

1-Install foam as per dwg D3798 using contact cement

A/R Contact Cement batch: 112983

2- Trim foam if necessary

0.00

0.00

RT 09 10-24

Work Order ID 52890

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Page 5

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Item Name: Spacepod Floor

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Setup Start



Stop



Start Date: 10/19/09 Start Qty: 1.00
Required Date: 10/20/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2> Sorholz

0.00

2041
40

✓

230

Packaging
Packaging

Identify as per dwg & Stock Location: *

0.00

0.00

Memo

7/10/26

2041

240

QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09-10-28

PL 09-10-24

Picklist Print

October 19, 2009 8:35:31 AM

Page 1

Work Order ID: 52890

Parent Item: D3798-041RevA

Parent Item Name: Spacepod Floor


Comments:

Start Date: 10/19/09

Required Date: 10/20/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	52.2622	9.2568			
												
6061-T6 .050 Sheet												

B9-10-19

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

52.2621

110791

34.5715

112567

15.6906

17349

2

112567

D3798-3RevA

Manufactured

No

170

Each

9.0000

1.0000



Spacepod Floor Foam



B 5280% #071026

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

9

46206

1

51098

4

52808

4

D3798-5

Manufactured

No

170

Each

10.0000

1.0000



Reinforcement



EP 07/10/20

Warehouse Loc Qty Loc Code
Location

Main Warehouse

GA

10

52807

10

1

Picklist Print

October 19, 2009 8:35:31 AM

Page 2

Work Order ID: 52890

Parent Item: D3798-041RevA

Parent Item Name: Spacepod Floor


Comments:

Start Date: 10/19/09

Required Date: 10/20/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-  Rivet		Purchased	No			210	Each	0.0000	33.0000			

M15541



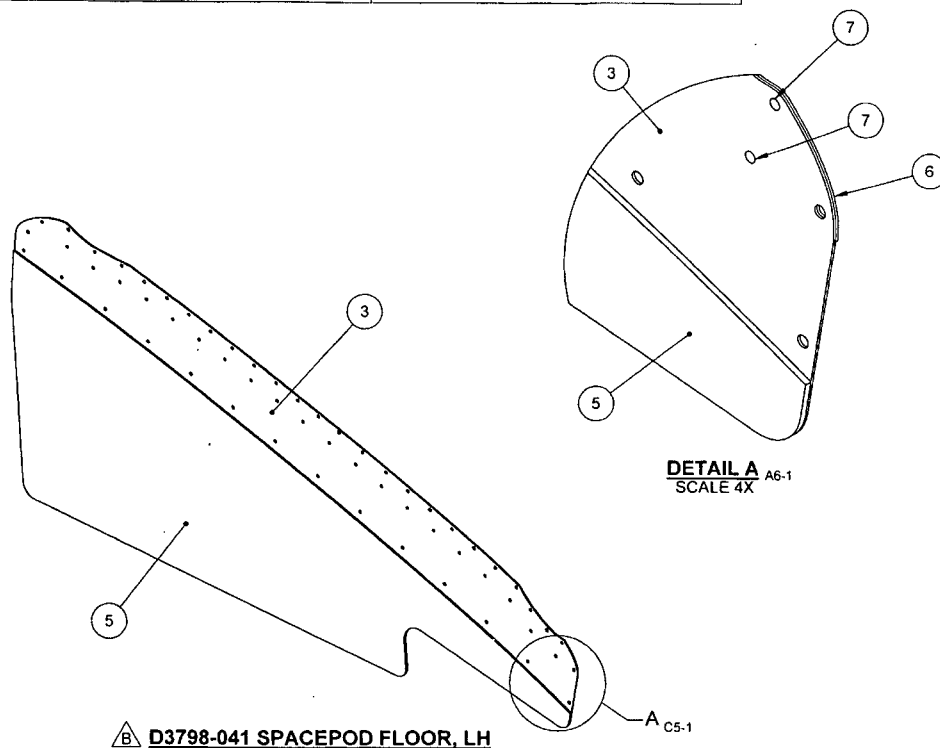
09/10/20

October 19, 2009 8:35:31 AM

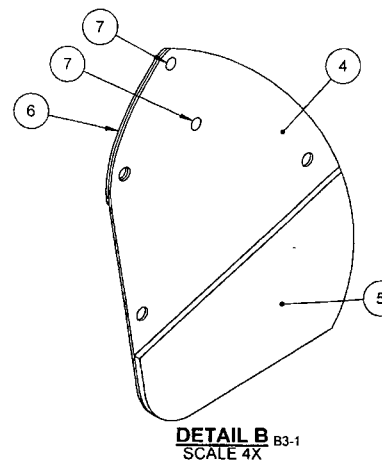
Shop Packet Print

Page 2

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



B D3798-041 SPACEPOD FLOOR, LH



B D3798-042 SPACEPOD FLOOR, RH

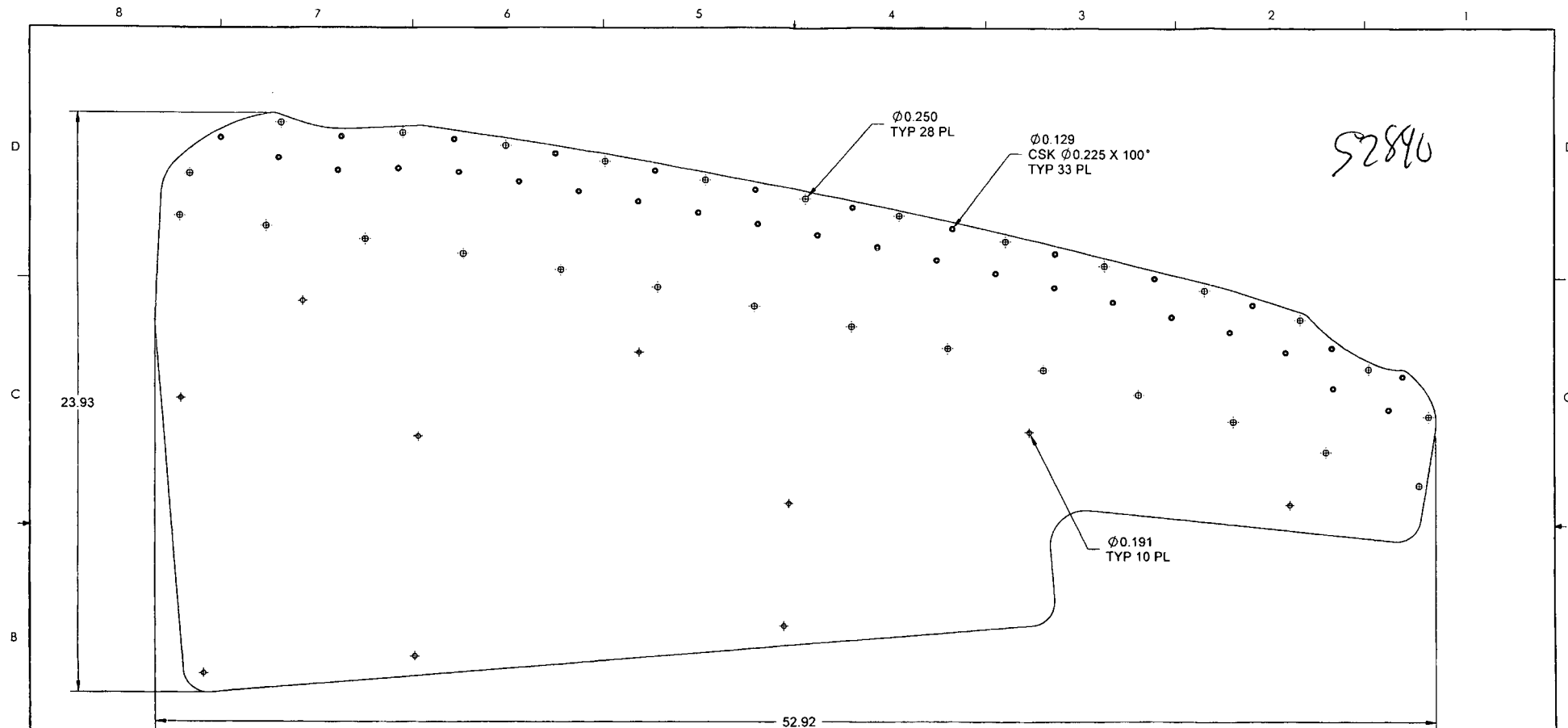
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs
D3798-042 - 5.0 lbs

- B 8) ASSEMBLY INSTRUCTIONS**
- RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
 - POWDER COAT PER NOTE 2
 - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

RELEASED
2009-10-13

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION		
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3798-1 SPACEPOD FLOOR

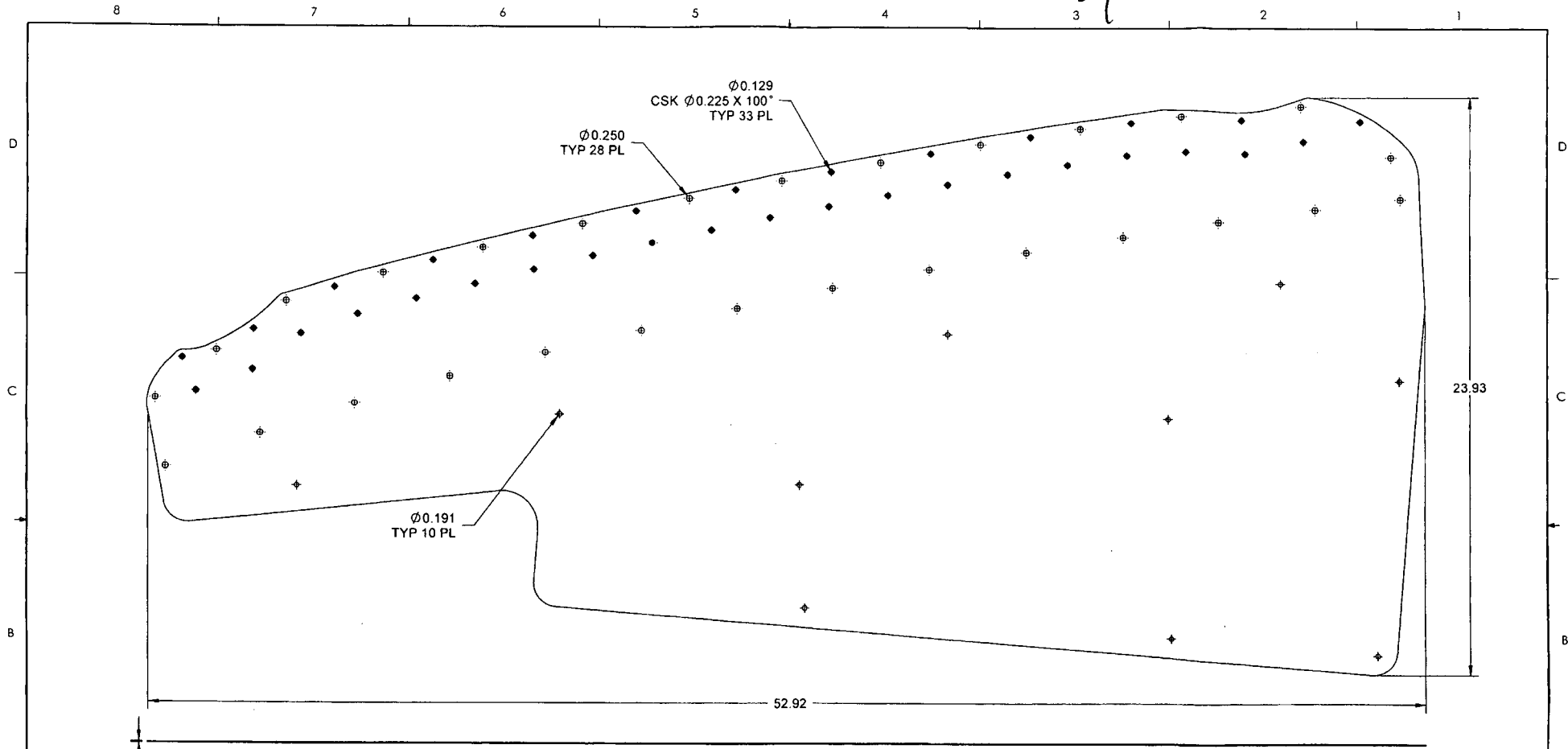
RELEASED
2009-10-13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S 050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 2 OF 5
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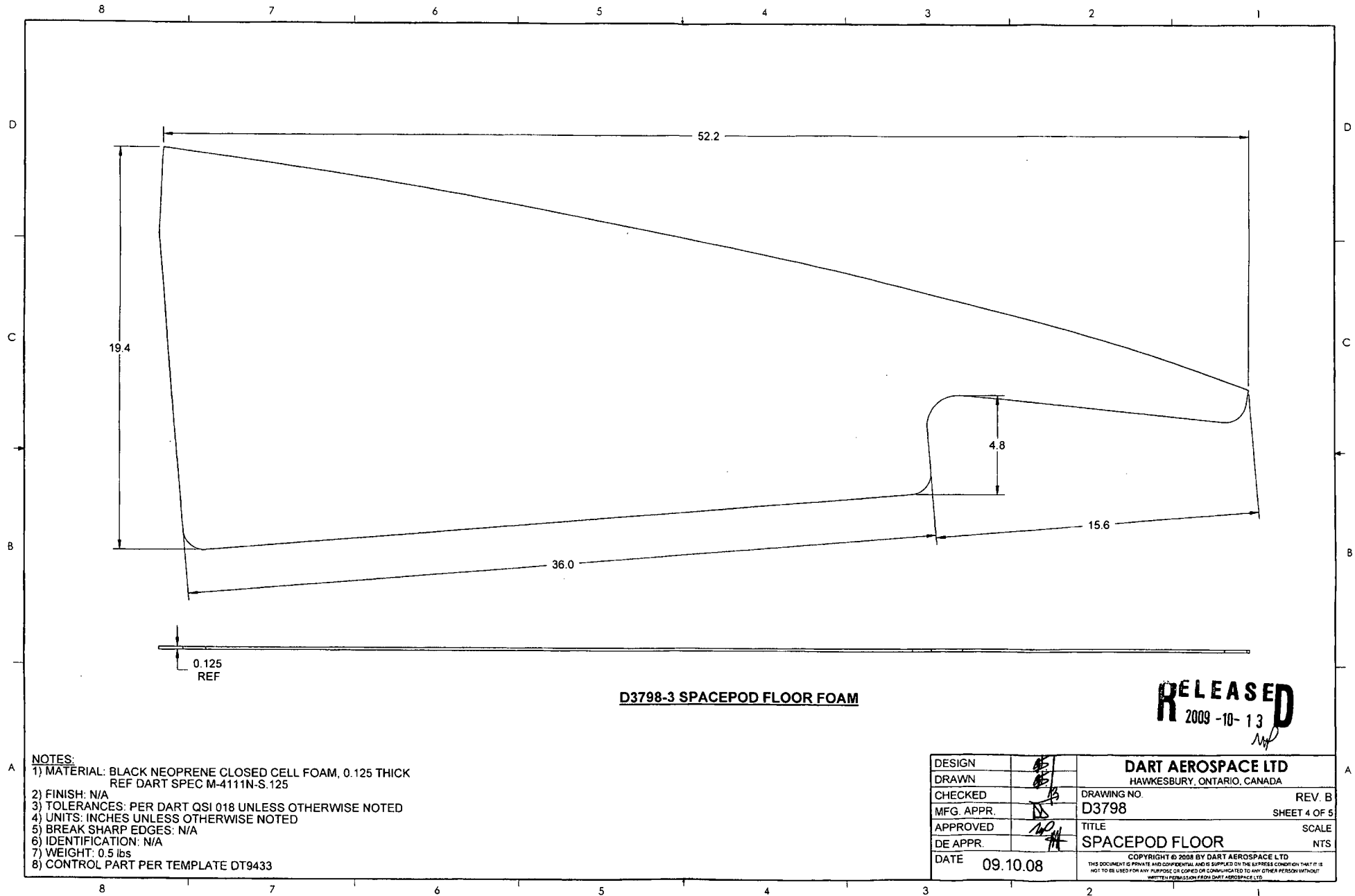
D3798-2 SPACEPOD FLOOR

RELEASED
2009-10-13
MD

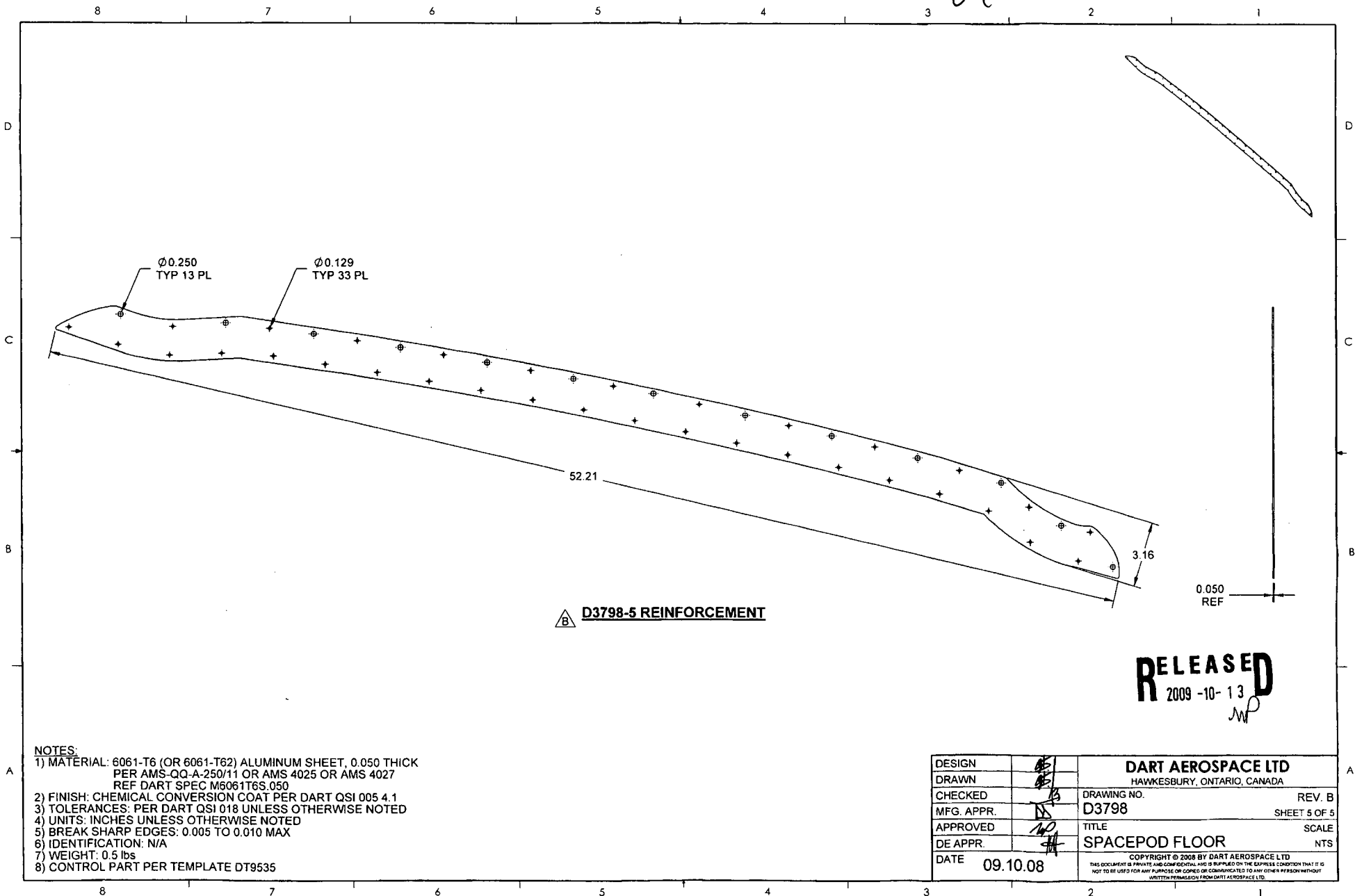
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.0 lbs
 - 8) CONTROL PART PER TEMPLATE DT9432

DESIGN	51	DART AEROSPACE LTD	
DRAWN	51	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	15	D3798	SHEET 3 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	14	SPACEPOD FLOOR	NTS
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WU 52890



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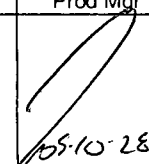
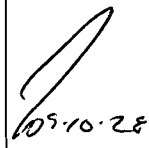


D3798-5 REINFORCEMENT

RELEASED
2009-10-13

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.5 lbs
 - 8) CONTROL PART PER TEMPLATE DT9535

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 5 OF 5
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W/O: 52890		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-10-28	W/O Dwg Lender Box	Add dwg D 3798 Rev-B to box per change		09/10/28		 09-10-28	 09-10-28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries